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D3589-5**Job Sheet 194049****Part No:** D3589-5**Job Qty:** 6 pcs**Part Name:** Latch Guide**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/25/19**Job Tracking No:****Due Date:** 5/10/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV C SHEET 4 IPP Rev:A 08-05-29 new issue DD verified by:EC IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	6 pcs	5/10/19	5/10/19	0.00	0.52	Hardinge - 1		JBD 19/05/01
120	QC 8	6 pcs	5/10/19	5/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Packaging 3-1 - Stock - B4B	6 pcs	5/10/19	5/10/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	Pc. MAY 03 2019
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
					9-69
140	QC 21 - SA	6 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					MAY 06 2019

Part Op **100** - (Hardinge) 1-TURN AS PER FOLIO FA755 & DWG D3589 FOLIO REV: AA DWG REV: C 2-DEBURR
 Descriptions: AS REQUIRED

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	1.4220 ft (.237 ea)	100-Hardinge - 1	5166227

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M304TR0.500W.049	1	190	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Latch Guide	0.500inches $\pm$ 0.010	0.510 0.490	Diameter	
2	Latch Guide	2.750inches $\pm$ 0.030	2.780 2.720		
3	Latch Guide	0.030inches $\pm$ 0.030	0.060 0.000		
4	Latch Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
5	Latch Guide	0.049inches $\pm$ 0.010	0.059 0.039		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



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Container No: S177097



Part: D3589-5

Job No: 194049

Serial No/Batch: S177097

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/01/19